Work Order ID 52290

Tuesday, September 22, 2009 1:56:50 PM

Item ID: D3875-1
Revision ID: A
Item Name: Floor Protector

Start Date: 9/23/2009 **Start Qty:** 5.00
Required Date: 10/9/2009 **Req'd Qty:** 5.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** R/mF **Date:** 09-22 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3875	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							09/29/09 BB
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								
110		0.00				5			09/29/09 BB.
Thermoform	**Memo**	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435 Dwg Rev: A Folio Rev: A								

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Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							09/29/09 (x5) BB
QC	**Memo**	0.00							
Quality Control	Visuallly inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							09/29/09 (x5) Wh
QC	**Memo**	0.00							
Quality Control									
140		0.00							09/30/09 (x5) Wh
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							09/30/09 (x5)
QC	**Memo**	0.00							
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00				(x5)	0		
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: FAC	0.00							
Packaging	**Memo** 50914	0.00							
Packaging									

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Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00				_____	09/10/08		
QC	**Memo**	0.00							
Quality Control									

W 9.10.08

Picklist Print

Tuesday, September 22, 2009 1:56:49 PM

Work Order ID: 52290

Parent Item: D3875-1RevA

Parent Item Name: Floor Protector

Comments:

Start Date: 9/23/2009 **Required Date:** 10/9/2009

Start Qty: 5.00 **Required Qty:** 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	445.6200	49.2000	5	09/29/09 BB	

Lexan Sheet

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	445.62		
111588	445.62		M111588

DART AEROSPACE LTD	Work Order:	52220
Description: Floor Protector	Part Number:	D3875-1
Inspection Dwg: D3875 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 09/30/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.080	✓			
0.080	Min	0.084	✓			
45.2	+/-0.100	45.6				REF ONLY 09.05.30
21.8	+/-0.100	21.85	✓			
1.4	+/-0.100	1.4	✓			

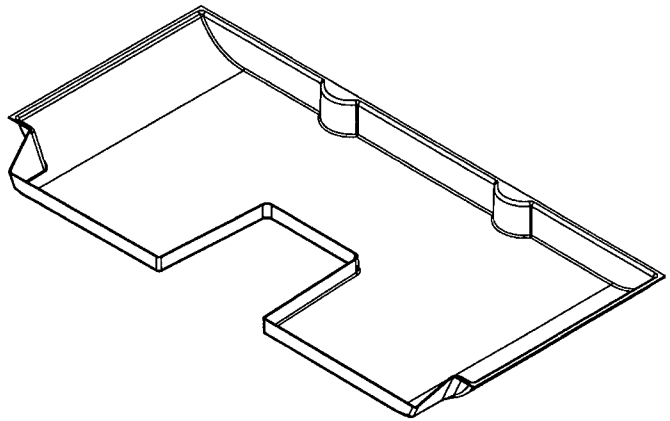
Measured by: DL Date: 09/30/09

Audited by: C Date: 02/10/08

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52290



D3875-1 FLOOR PROTECTOR (206B)

RELEASED
29/05/09 MP

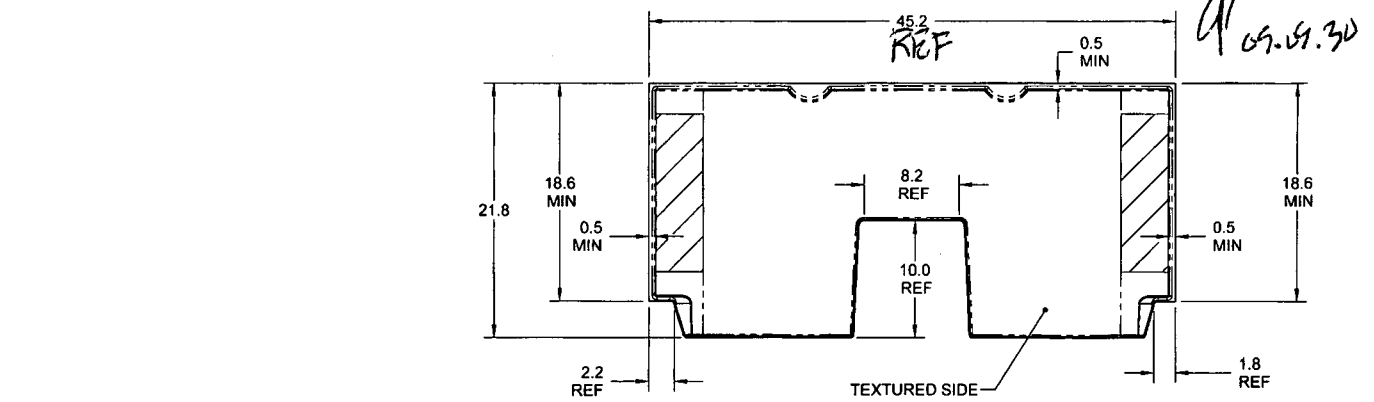
NOTES:
1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR
(MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
7) WEIGHT: 4.0 lbs
8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

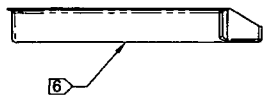
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	PH	09.01.29

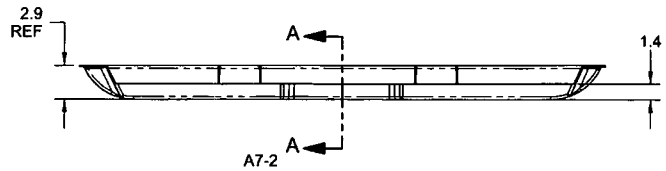
DESIGN	AG	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AG	
CHECKED	LB	DRAWING NO. D3875 REV. A
MFG. APPR.	DE	SHEET 1 OF 2
APPROVED	AG	TITLE FLOOR PROTECTOR (206B) SCALE NTS
DE APPR.	AG	
DATE	09.01.29	

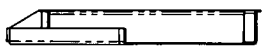
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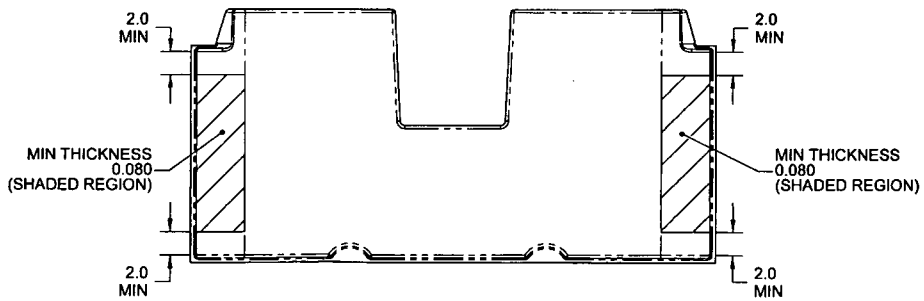
52290











SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

RELEASED 09/05/05

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3875 REV. A SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE FLOOR PROTECTOR (206B) SCALE NTS
DE APPR.		
DATE 09.01.29		

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